

Work Order ID 62259

September 23, 2010 1:24:12 PM

Page 1

Item ID: D350-604-041

Accept

Revision ID:

Item Name: Rear Locker Extender

Start Date: 9/23/10 Start Qty: 1.00

Required Date: 10/08/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: CZ Date: 10/9/23 Tooling:

QC: Date: SPC (Y/N):

Cust Item ID:

Customer:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D2273	D
-------	---

D350-604-041	A
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DSI9470	A
---------	---

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels per PPP D350-604-041 CHG002

8/20/14

HJ for BG 10-10-18

110

0.00



Purchasing

Purchasing

PURCHASING

Memo

0.00

Issue P/O: 12638

Description: D350-604-041 Rear locker extender.

Supplier: Delastek.

Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B 115502

CZ 10/9/23 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62259

September 23, 2010 1:24:12 PM

Page 2

Item ID: D350-604-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Rear Locker Extender

Start Date: 9/23/10 Start Qty: 1.00

Required Date: 10/08/10 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date: Tooling:

Date:

Run Start

QC: Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Receive & Inspect for Damage & Mat'l Certs
Packaging

0.00

Packaging

Memo

0.00

Packaging

Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.

130

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Check hole locations to template. DT 8824 Check process sheet and audit.

140

Pick Kit

0.00

Packaging

Memo

Packaging

0.00

P25 Small Pab

P15→

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-604-041 PAR #: _____ Fault Category: Supplier Delaslek NCR: ☒ Yes No DQA: [Signature] Date: 10-11-11
 Resolution: re-work Disposition: rework QA: N/C Closed: [Signature] Date: 10/11/12

NCR: <u>62259-1</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/10/10	100	Medium size crack found in upper corner of Rear locker in the gel coat. R.C. Sublimar	<u>[Signature]</u>	→ re do gel coat per Q57006 Gel 944 w 005	<u>[Signature]</u> 10-11-10	<u>[Signature]</u> 10/10/10	<u>[Signature]</u>	<u>[Signature]</u> 10/10/26
		Note include this as part of corrective action During rework	<u>[Signature]</u>	→ Inform Delaslek of issue found. Please attach email sent to Delaslek /Delaslek	<u>[Signature]</u> 10-11-11	<u>[Signature]</u> 10/11/11	<u>[Signature]</u>	<u>[Signature]</u> 10/10/26
10-11-10	110	1 can lock stud + 1 retaining washer no more good R.C. rework process.	<u>[Signature]</u>	scrap + replace 2600-CY B 115814 2600-LW B 11581	<u>[Signature]</u> 10-11-10	<u>[Signature]</u> 10/11/10	<u>[Signature]</u>	<u>[Signature]</u> 10/11/10

NOTE: Date & initial all entries

Work Order ID 62259

September 23, 2010 1:24:12 PM

Page 3

Item ID: D350-604-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Rear Locker Extender

Start Date: 9/23/10 Start Qty: 1.00

Required Date: 10/08/10 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

8/26/10

Quality Control

160

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-604-041

Location: *52*PPP Rev: *6**10/11/10*

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/11/10**10-11-10**(1)*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

September 23, 2010 1:24:11 PM

Work Order ID: 62259



Parent Item: D350-604-041



Parent Item Name: Rear Locker Extender

Start Date: 9/23/10

Required Date: 10/08/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: Q ☐ 03.12.01 ☐ Reformat ☐ KJ/RF ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2600-6 Camlock Stud		Purchased	No			110	Each	73.0000	4	4			

Location	Loc Qty	Loc Code
ST381	73	
114238	4	
114355	4	
115502	35	
115581	30	

S D2268

Decal

Manufactured	No		140	Each	10.0000	1
--------------	----	--	-----	------	---------	---

Location	Loc Qty	Loc Code
ST010	10	
60213	10	

S D2269

Decal

Manufactured	No		140	Each	6.0000	1
--------------	----	--	-----	------	--------	---

Location	Loc Qty	Loc Code
ST010	6	
60214	6	

D350-604-041P

Rear Locker Extender

Purchased	No		120	Each	0.0000	1
-----------	----	--	-----	------	--------	---

4 C21019124

10/10/18 SP

1362244 10/10/18 SP

10/10/18 SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

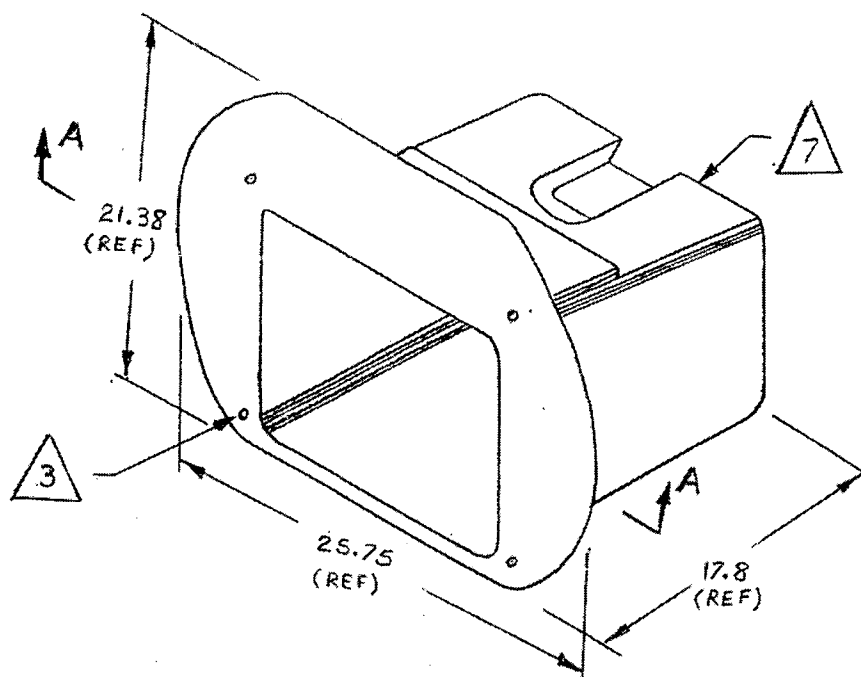
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

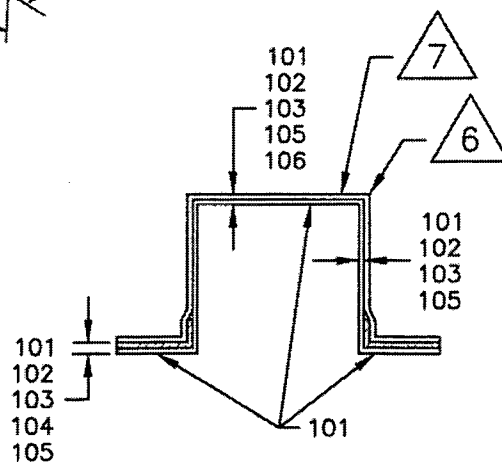
DESIGN	JB	DRAWN BY	JP	DART AEROSPACE LTD	REV. D
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	S	DRAWING NO.	SHEET 1 OF 1
				D2273	
DATE	02.04.01			TITLE	SCALE
				350 REAR LOCKER EXTENDER	NTS
B	96.05.27	RE-DRAWN			
C	02.01.30	CLARIFY MATERIAL, LAYUP, AND TOOLING			
D	02.04.01	REMOVE EPOCAST, ADD SURFACE FINISH			

RELEASED
02.04.03

02/10/19/23
W/D: 62259

NOTES:

- 1) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING.
- 2) LAYUP USING DT8010 MOLD. WET LAYUP NO BAG/VACUUM.
- 3) TRIM & DRILL PER DT8020. OPEN HOLES TO $\phi 0.257$ (4 PLACES).
- 4) MATERIALS:
RESIN: DERAKANE 470-36/411/510A40
FIBRE: 9oz = 9.7 oz 7781 WEAVE "S" GLASS
18oz = 18.0 oz ROVING "E" GLASS.
- 5) CONSTRUCTION:
101-WHITE GLOSS GELCOAT # GEL 944W005.
102-9oz ALL OVER.
103-18oz ALL OVER.
104-18oz RE-INFORCE FRONT FLANGE EXTENDING 2" ON SIDES.
105-9oz ALL OVER.
106-PEEL PLY.
- 6) MATTE TO HOLD DOWN CORNERS AS REQUIRED.
- 7) FINISH THIS SURFACE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S.
- 8) ALL DIMENSIONS ARE IN INCHES.

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-604 REV. B

REF TCCA STC: SH90-4
REF FAA STC: SR00463NY

62259

PURPOSE:

The 2600-4 Camloc Studs may be too short for some installations.

CHANGE:

The qty (4) 2600-4 Camloc Studs are replaced with longer 2600-6 Camloc Studs. It is acceptable to install either 2600-4 or 2600-6 Camloc Studs. The parts list of D350-604 Rev. B is amended as follows:

QTY	PART NUMBER	DESCRIPTION
-041		
X	D350-604-041	REAR CARGO COMPARTMENT EXTENDER ASS'Y

IS:

4	2600-6	CAMLOC STUD
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WAS:


4	2600-4	CAMLOC STUD
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CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

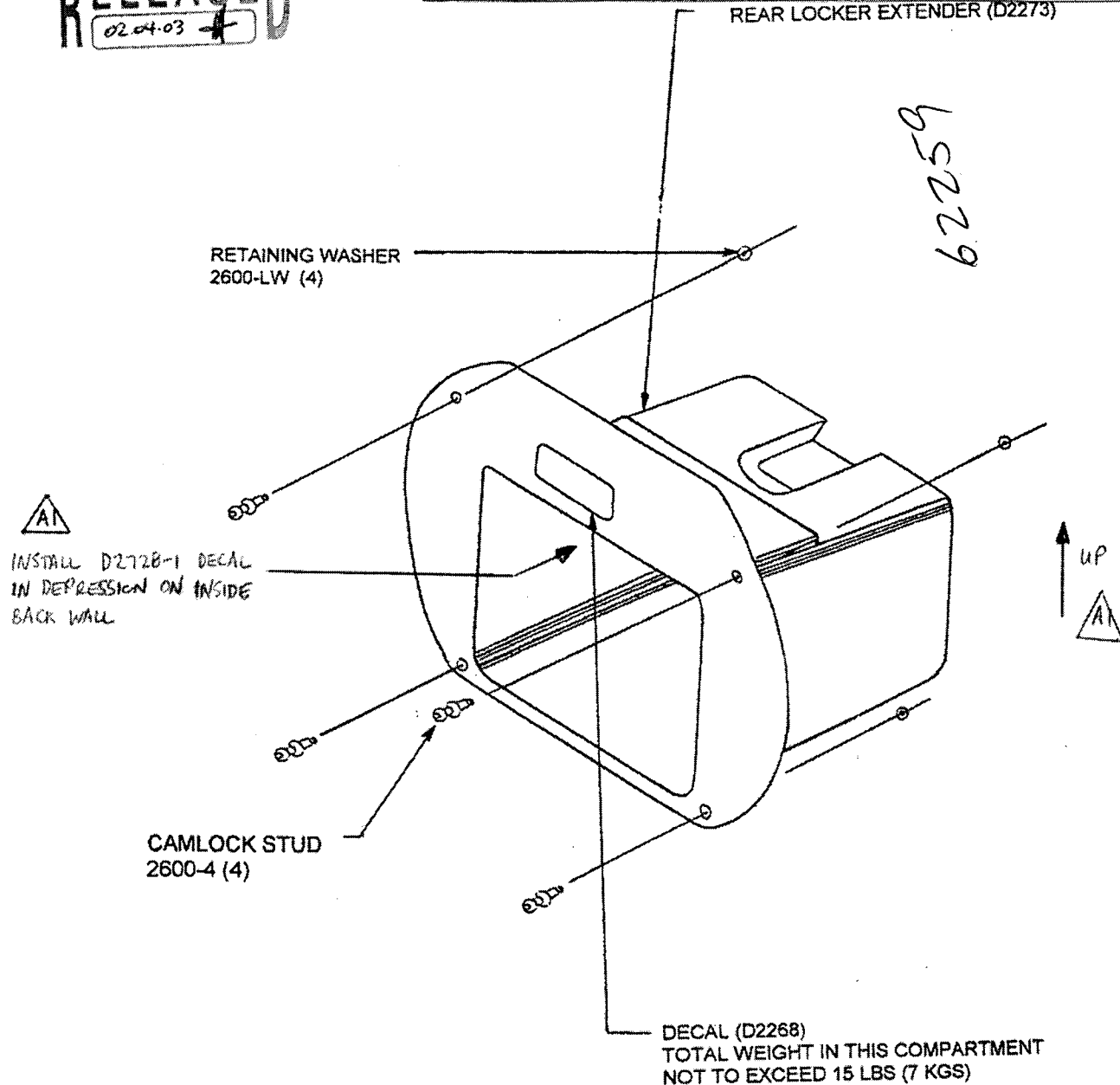
BY: 
D. SHEPHERD (DE # 02)

DATE: 09.07.01
CERT. NO.: SH90-4
ISSUE NO.: 3

A	NEW ISSUE, NCR 09-046	CP	09.07.01
REV.	DESCRIPTION	BY	DATE
DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	97		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	VIA	DSI 9470	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CAMLOC CHANGE	NTS
DATE	09.07.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART

DESIGN BW	DRAWN BY JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D350-604-041	REV. A SHEET 1 OF 1
DATE 02.04.01		TITLE REAR LOCKER EXTENDER ASSEMBLY	SCALE NTS
A	02.04.01	NEW ISSUE	
A1	# RF 02.04.23	ADD D2728-1 DECAL + ORIENTATION NOTE REAR LOCKER EXTENDER (D2273)	

RELEASED
02.04.03

D350-604-041 REAR LOCKER EXTENDER

NOTE: DECALS TO BE ORIENTED TO MATCH 'UP' ORIENTATION OF RLE



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AERONAUTIQUE

Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	35282
Customer #	DART US

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

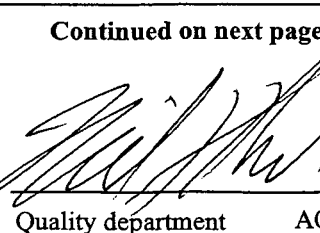
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
14/10/2010	27/09/2010	15474	Chantal Lavoie		PO12638		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0003	Line #1 Rear Locker Extender D350-604-041P B62255 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D <u>No. série</u> <u>No. lot</u> B62255 28715			
1	0	1	DKC134-0003	Line #2 Rear Locker Extender D350-604-041P B62259 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D <u>No. série</u> <u>No. lot</u> B62259 28717			
1	0	1	DKC134-0003	Line #3 Rear Locker Extender D350-604-041P B62260 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D <u>No. série</u> <u>No. lot</u> B62260 29228			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Continued on next page

Accepted by:


Quality department



AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.



Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	35282
Customer #	DART US

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
14/10/2010	27/09/2010	15474	Chantal Lavoie		PO12638		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0003	LINE #4 Rear Locker Extender D350-604-041P B62261 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D <div><div>No. série</div><div>No. lot</div><div>B62261</div><div>28716</div></div>			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Mercredi, 2010-09-08 11:25:56
Utilisateur: Pascal Carignan

Feuille de Procédé

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: REAR LOCKER EXTENDER
Numéro Job	: 28717	Numéro Article	: DKC134-0003
Numéro Soumission	: 3482	Numéro Dessin	: D350-604-041 & D2273
Numéro B.A.	:	Projet Numéro	: DK-362
Cette fois	: 2010-09-08 No. B.V. :	Révision dessin	: A & D
Prsht Rev.	: NC	Matériel	: Derakane 470-36/411/510
Prem. fois	: - - Type :	Date Dûe	: 2010-09-15 Qté: 1 UdM: UNITE
Job précédente	: 28716		

Écrit par : _____
Véifié & Approuvé par : _____
Commentaires : N° de pièce Laminée Dart Aerospace: D2273
N° de pièce Assemblage Dart Aerospace: D350-604-041

B 62259

Process Sheet Rév.: 00 Création du premier à partir de la révision
12 du planning De Delastek Composites

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 AC0085 FREKOTE 3,78L 44-NC

Commentair Qty.: 0.02 UNITE(s)/Unit Total : 0.02 UNITE(s)

2.0 PRÉPARATION Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Nettoyer le moule à l'aide d'un chiffon humide et sécher à l'air. Selon I.F. # DKC134-0003-5.

Note: Afin que le frekote agisse pleinement, le moule doit être libre de toute contamination, enlever tout contaminants à l'aide de Frekote PMC, PMC Plus ou tout autre solvant afficace. Il est permit d'utiliser un abrasif (Doux) afin d'enlever tout accumulation de résine sur le moule.

Appliquer 2 couches de Frekote 44-NC à l'aide du chiffon propre en laissant sécher pendant 15 minutes entre les couches. Le séchage de la dernière couche doit être de 3 heures à température de la pièce avant d'appliquer le Gel Coat.

Date: _____ Sceau: _____

3.0 AMB0350 Gel Coat Blanc N° Gel 944W005

Commentair Qty.: 1.580 UNITE(s)/Unit Total : 1.580 UNITE(s)
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-28605-1

4.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-22176-1

Date: Mercredi, 2010-09-08 11:25:56
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 28717

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



Séq.:

Machine ou Opération:

Description :

5.0

AC0747

Acetone

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)

6.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire la préparation du matériel selon I.F. # DKC134-0003-5 :

Dans une quantité de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% D'acétone.

Date: 30-9-10 Sceau:



7.0

GEL COAT

Application du Gel Coat



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Selon I.F. 134-0003

À l'aide d'un fusil à gel coat appliquer une couche entre 15 et 20 millièmes de Gel Coat sur le moule N° DKG 362-010 et laisser sécher pendant un minimum de 2 heures avant de faire le lay-up, mais ne pas dépasser 24 heures de séchage selon l'instruction de travail N° Tec-70.

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Autocontrôle de fabrication. (Visuel du Gel Coat)

Date: 30-9-10 Sceau:



8.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.680 LITRE(s)/Unit Total : 1.680 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot:

1-28244-1

9.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-22176-1

10.0

AMB0214

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 4.6 VERGE(s)/Unit Total : 4.6 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot:

1-27985-1

Date: Mercredi, 2010-09-08 11:25:56

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 28717

Numéro Article: DKC134-0003

Numéro Job:



Séq.:

Machine ou Opération:

Description :

11.0

AMB0213

WR1850 Roving 18oz. x 50"

Commentair Qty.: 1.140 KILOGRAMME(s)/Unit Total : 1.140 KILOGRAMME(s)

WR1850 Roving 18oz. x 50"

N° de Lot: 1-22300-1

12.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler le matériel selon les dimensions requises à l'aide de gabarit de trimage prévus à cet effet.

Autocontrôle de fabrication. (Selon gabarits)

Date: 27 Sept 2010 Sceau:



13.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 3.5000Hrs Total Run : 3.5000Hrs

Selon I.F. 134-0003

S'assurer de ne pas trapper d'air entre les rangs

Inscrire les informations suivantes:

Humidité: 41 % Température: 73 °F Heure: 1:45

Date: 30-9-10 Sceau:



14.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.150 LITRE(s)/Unit Total : 0.150 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot: 1-28244-1

15.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-22176-1

16.0

FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Injecter les bulles d'air selon I.F.# DKC134-0003-5.

Date: 4-10-10 Sceau:



Date: Mercredi, 2010-09-08 11:25:56

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 28717

Numéro Article: DKC134-0003

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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17.0	DÉMOULAGE	Démoulage de la pièce
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Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Selon I.F.# DKC134-0003-5.

Faire le démoulage de la pièce en poussant de l'air à l'intérieur tout en faisant bien attention de ne pas l'endommager .

Autocontrôle de fabrication.(Visuel)

Date: 1-10-10 Sceau:



18.0	TRIMAGE	Trimage
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Commentair Setup: 0.00Hrs/ Run: 40.0000Min Total Run : 0.6667Hrs

Selon I.F.134-0002

Autocontrôle de fabrication.(Visuel et dimensionel selon le dessin)

Date: 7-10-10 Sceau:



19.0	AAC1021	Dupont Primer N° 7704S
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Commentair Qty.: 0.3400 UNITE(s)/Unit Total : 0.3400 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-28050-2

20.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase
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Commentair Qty.: 0.0670 UNITE(s)/Unit Total : 0.0670 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-28382-1

21.0	PRIMER	Application primer
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Appliquer le primer selon I.G. 0008

Date: 12-10-10 Sceau:



22.0	AAC1607	Camlock Stud 2600-4 (or Monadnock 1126000-4)
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Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)

Camlock Stud 2600-4 (or Monadnock 1126000-4)

N° de Lot: 1-27869-1

Date: Mercredi, 2010-09-08 11:25:56

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 28717

Numéro Article: DKC134-0003

Numéro Job:



Séq.: Machine ou Opération: Description :

23.0 AAC0682 Washer 2600-LW (1127700)

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)

Washer 2600-LW (1127700)

N° de Lot:

1-6687-1

24.0 ASSEMBLAGE Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Selon I.F. 134-0004

Démasquer la pièce.

Assembler les quatre (4) Camlock Stud N° 2600-4 à l'aide des Lock Washer N° 2600-LW. Selon l'instruction de travail N° I.G.#Pose de stud.

Autocontrôle de l'assemblage (Visuel)

Date: 14/10/10 Sceau:



25.0 IDENTIFICATION Identification à encre indélébile



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Selon I.F. 134-0005

Faire l'identification de la pièce: N° de pièce D350-604-041

N° de Work Order:

L'identification doit être vers l'extérieur.

Date: 14/10/10 Sceau:



26.0 INSPEC FINAL Inspection finale



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Date: 14-10-10 Sceau:



27.0 EMBALLAGE Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'emballage de la pièce dans le contenant approprié.

Date: Mercredi, 2010-09-08 11:25:57

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 28717

Numéro Article: DKC134-0003

Numéro Job:



Ség.:

Machine ou Opération:

Description :

Date: 14/04/10 Sceau: MC

Jason Murdoch

From: Jason Murdoch [jmurdoch@dartaero.com]
Sent: Tuesday, July 13, 2010 9:17 AM
To: 'Céline Audet'
Cc: 'L Lacelle'
Subject: Rear lockers D350-604-041P
Attachments: PO 12085 Del wo#26290.JPG; PO 12085 Del wo#26290 (1).JPG; PO 12085 Del wo#26290 (2).JPG; PO 12085 Del wo# 26291.JPG; PO 12085 Del wo# 26291 (1).JPG; PO 12085 Del wo# 26291 (2).JPG

Hi Celine,

I Thought you guys should be advised of the last 2 issues we have encountered on these rear lockers.

On you w/o 26290, the thickness of the gelcoat in the affected area was measuring 0.045-49" thick. Away from the radius, was 0.025" which is acceptable. Is it possible that the additional thickness in Gel coat is the cause of cracking on & around the corners? This was discovered with a minor flex of the flange....I mean very minor.

& on w/o 26291, well it is pretty obvious that the primer was a wee bit too thick in this area, & cracked once fully cured.

Please pass on the message of the gelcoat & primer & note that this applies to all product unless otherwise specified.

We will rework these deviations in house.

Thanks,

Jason Murdoch
Quality Coordinator
jmurdoch@dartaero.com
DART Aerospace Ltd.
613-632-5200